

Work Order ID 81346

81346

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March-13-12 1:34:57 PM

Item ID: D3508-9 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 13/03/2012 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 27/03/2012 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/13 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3508	Rev C

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3508 Dwg Rev: C Prog Rev: C 2-
 304 - OAC Debur if necessary

1312-3-29

(12)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110
 QC Memo 0.00
 Quality Control

1312-3-29

120 QC8- Inspect parts - second check 0.00

120
 QC Memo 0.00
 Quality Control

8.2/8/12

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Deburr and form on brake using DT8326 and DT8261 as per Dwg D3508	0.00 0.00				(12)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/12/04/02		(42)			
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 7h15 FINISH TIME: 7h45 OVEN TEMPERATURE: 320°F	0.00 0.00		12 12/04/03		(28)			

m117338

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
						12	12	12-4-3	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP1</u> Memo	0.00 0.00							
						12	SP	12/04/03	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
								12/4/3	

11 12-04-3

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Picklist Print

March-13-12 1:35:01 PM

Page 1

Work Order ID: 81346

81346

Parent Item: D3508-9

D3508-9

Parent Item Name: Wearplate

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	163.6165	0.417	5.267368			

M304S20GA

304/316 .040 Sheet

BIL-3-29

Location

Loc Qty

Loc Code

MAT020

163.6165

116623

0.2

117933

27.3442

118400

21.1723

118964

36.5

119346

29.8

120604

48.6

120604

(12)

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DART AEROSPACE LTD		Work Order:	81346
Description: Wearplate		Part Number:	D3508-9
Inspection Dwg: D3508 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.070	2		V B62	
2.813	+/-0.010	2808	2		V	
0.375	+/-0.010	373	2		V	
2.90	+/-0.030	2.907	2		V	
5.800	+/-0.010	5.800	L		T B61	
11.600	+/-0.010	11.600	L		T	
17.400	+/-0.010	17.400	5		T	
Ø0.188	+0.005/-0.001	.190	2		V	
0.300	+/-0.010	.302	1		V	
0.300	+/-0.010	.301	L		V	
0.038	+/-0.010	.039	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-3-09	Date: 12/3/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	DD

Dart Aerospace Ltd

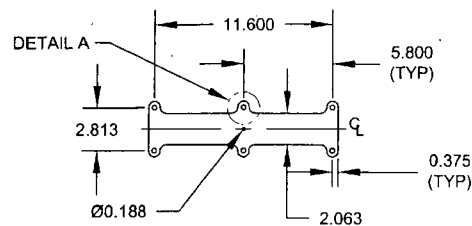
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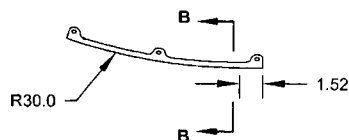
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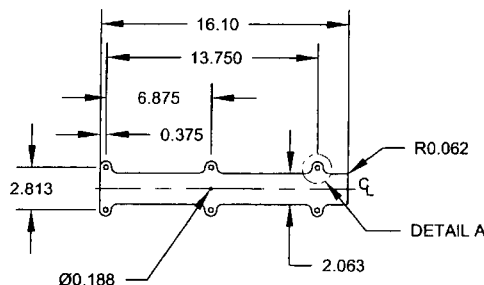
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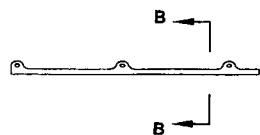
D3508-1 FLAT PATTERN



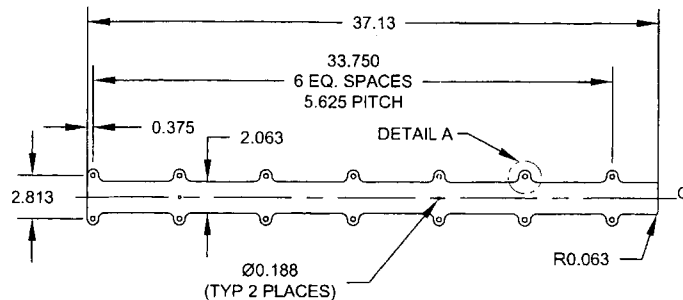
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



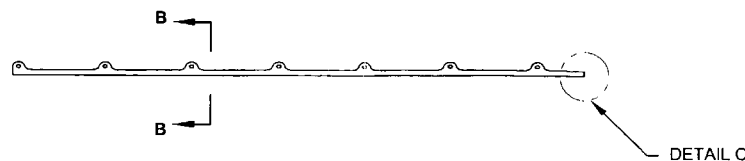
D3508-7F FLAT PATTERN



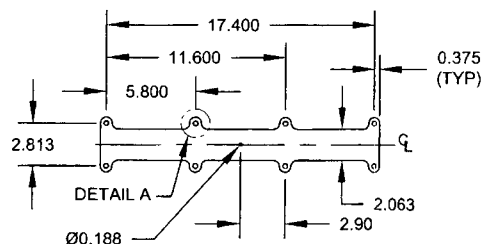
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(MAKE FROM D3508-7F)



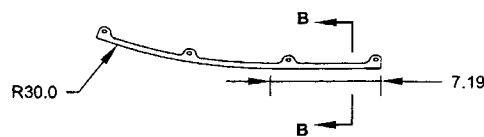
D3508-3 FLAT PATTERN



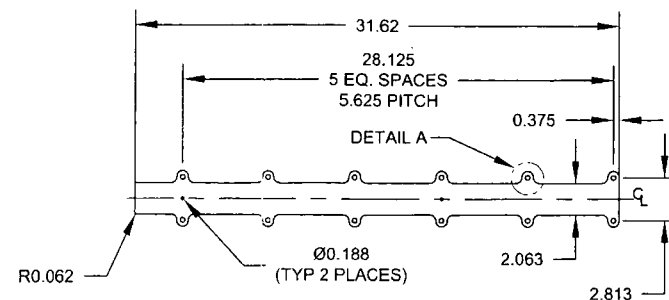
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



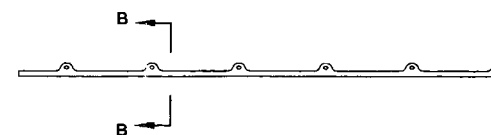
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07.11.16

C	ADD -9/11/13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.20		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3508
REV. C
SHEET 1 OF 2

TITLE WEARPLATE
SCALE 1:8

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81346 MLJ 12/03/13

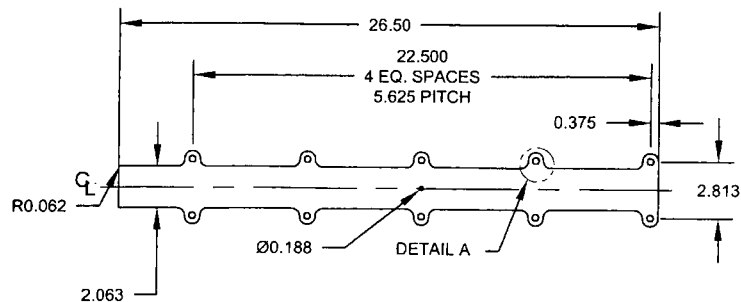
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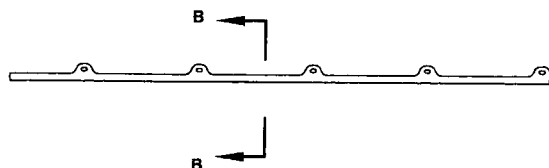
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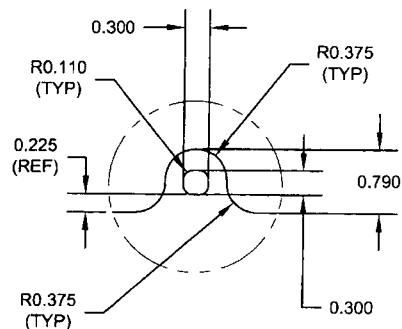
NOTE: Date & initial all entries



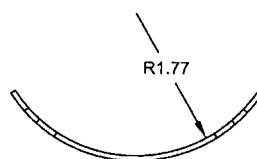
D3508-11F FLAT PATTERN



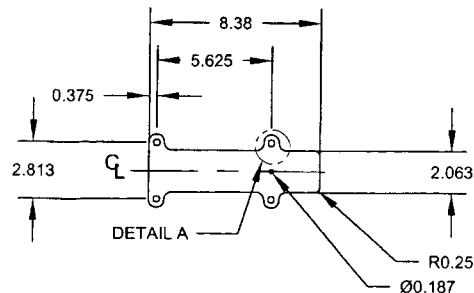
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



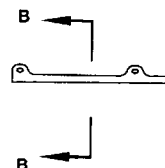
DETAIL A
(SCALE 2:3)



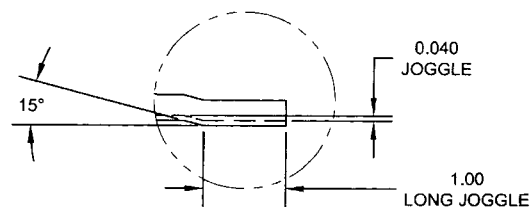
SECTION B-B
(SCALE 2:3)



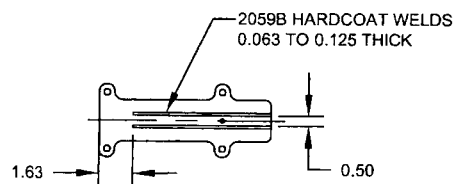
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

RELEASED
07.11.16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO. D3508	REV. C
MFG. APPR.	PH	SHEET 2 OF 2	
APPROVED	PH	TITLE WEARPLATE	SCALE 1:6
DE APPR.	PH	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
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